



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4103-1

Job Sheet 197816



Part No: D4103-1

Job Qty: 20 pcs

Part Name: Step / Handle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/17/19

Job Tracking No:

Due Date: 7/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV: A NEW ISSUE 10-07-01 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		7/31/19	0.00	0.71	Bandsaw - 1		19/8/16
110	HAAS 4 Axis - B4B	20 pcs		7/31/19	0.12	25.64	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		19/8/16
							HAAS - 4 - B4B		
130	QC 8	20 pcs		7/31/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		19/8/18
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S203022



Part: D4103-1

Job No: 197816

Serial No/Batch: S203022

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/06/19

7/17/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

140	Handfinish - 1-1 Chemical-B4B	20 pcs	7/31/19	0.00	1.38	Handfinish - 1 - 1 - B4B	BEB 2019-08-20
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	QC 7	20 pcs	7/31/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	

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						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	AUG 21 2019 40
						QC 7 - 24	8-22
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
160	Packaging 3-1 - Stock - B4B	20	7/31/19	0.00	0.00	Packaging 3 - 1 - B4B	
	pcs					Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	NC. STOCK
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	

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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	20 pcs	7/31/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

21 AUG 21 2019
9-55

Part Op 100 - (Bandsaw) 6.200" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Mill as per dwg and Folio FA937
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - QC7-Inspect Chemical Conversion Coat
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X03.500	6061-T6 Bar 2.00 X 3.50	10.2000 ft (.51 ea)	100-Bandsaw - 1	541575 x 11 parts 85201866 x 9 parts

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X03.500	10	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step/Handle	2.930Inches ± 0.030	2.960 2.900	2.932	
2	Step/Handle	0.370Inches ± 0.030	0.400 0.340	0.369	
3	Step/Handle	0.830Inches ± 0.030	0.860 0.800	0.830	
4	Step/Handle	0.560Inches ± 0.010	0.570 0.550	0.558 Diameter	0.558
5	Step/Handle	0.060Inches ± 0.030	0.090 0.030	0.064	
6	Step/Handle	45.000Degrees ± 0.500	45.500 44.500	45° Angle	
7	Step/Handle	0.260Inches ± 0.030	0.290 0.230	0.280	
8	Step/Handle	0.330Inches ± 0.030	0.360 0.300	0.346	
9	Step/Handle	0.060Inches ± 0.030	0.090 0.030	Radius	0.060
10	Step/Handle	1.780Inches ± 0.030	1.810 1.750	1.784	
11	Step/Handle	0.450Inches ± 0.030	0.480 0.420	0.431	
12	Step/Handle	0.330Inches ± 0.030	0.360 0.300	0.352	
13	Step/Handle	0.750Inches + 0.000 - 0.030	0.750 0.720	0.750	
14	Step/Handle	1.660Inches ± 0.030	1.690 1.630	1.657	
15	Step/Handle	0.800Inches ± 0.030	0.830 0.770	0.646 (1800)	
16	Step/Handle	1.070Inches ± 0.030	1.100	1.070	

			1.040	
17	Step/Handle	3.850Inches ± 0.030	3.880 3.820	3.849
18	Step/Handle	0.030Inches ± 0.030	0.060 0.000	0.030
19	Step/Handle	45.000Degrees ± 0.500	45.500 44.500	45 Angle
20	Step/Handle	0.310Inches ± 0.030	0.340 0.280	0.303
21	Step/Handle	0.280Inches ± 0.030	0.310 0.250	0.277
22	Step/Handle	0.030Inches ± 0.030	0.060 0.000	0.030 Depth
23	Step/Handle	6.000Inches ± 0.030	6.030 5.970	6.000
24	Step/Handle	0.270Inches ± 0.030	0.300 0.240	Radius 0.27
25	Step/Handle	0.560Inches ± 0.030	0.590 0.530	0.586
26	Step/Handle	1.740Inches ± 0.030	1.770 1.710	1.740
27	Step/Handle	2.500Inches ± 0.030	2.530 2.470	2.50
28	Step/Handle	0.438Inches + 0.006 - 0.001	0.444 0.437	0.439 Diameter
29	Step/Handle	0.266Inches + 0.006 - 0.001	0.272 0.265	0.266 Diameter
30	Step/Handle	0.960Inches ± 0.030	0.990 0.930	0.960
31	Step/Handle	0.260Inches ± 0.030	0.290 0.230	0.260
32	Step/Handle	0.250Inches ± 0.030	0.280 0.220	0.240
33	Step/Handle	2.250Inches ± 0.030	2.280 2.220	2.250
34	Step/Handle	1.000Inches ± 0.030	1.030 0.970	1.000
35	Step/Handle	0.200Inches ± 0.030	0.230 0.170	0.200
36	Step/Handle	0.980Inches ± 0.030	1.010 0.950	0.980
37	Step/Handle	0.320Inches ± 0.030	0.350 0.290	0.320
38	Step/Handle	1.250Inches ± 0.030	1.280 1.220	1.250
39	Step/Handle	0.190Inches ± 0.030	0.220 0.160	Radius R0.190

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					